

Work Order ID 82060

Thursday, March 22, 2012 1:04:39 PM

82060

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Item ID: D3205-3 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Back Plate
 Start Date: 3/22/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 3/30/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference: REWORK

Approvals: Process Plan: mf Date: 12-03-22 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3205	Rev A								
190	Manufacture as per dwg	0.00				12	0		<u>12/03/27</u>
190									
Mill Conv	Memo	0.00							
Conventional Milling Machine	PULL FROM STOCK D3205-3 X 12 (2 X B69626, 10 X 70285)								
	REWORK PER NEW DRAWING AT REV B PER ECN 12-545								
200	QC5- Inspect part completeness to step on W/O	0.00				12	0		
200									
QC	Memo	0.00							
Quality Control	<u>12/31/28</u>								
210		0.00							
210									
HandFinish	Memo	0.00							
Hand Finishing	REALODINE AREA THAT WAS REWORKED AND TOUCH UP WITH GREY SANDTEX								

12/31/28
11/7 338

12 X 0 M/L 12/03/28
 Start Time: 2h05
 Temp: 320°F
 Finish Time: 2h35

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Item ID: D3205-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Back Plate
 Start Date: 3/22/2012 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 3/30/2012 Req'd Qty: 12.00 *12* Customer:
 Reference: REWORK

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC3- Inspect Part Finish	0.00							
220						12	BK 12328		
QC	Memo	0.00							
Quality Control									
230	Identify as per dwg & Stock Location: <u>GEA</u>	0.00							
230									
Packaging	Memo	0.00							
Packaging	ID AND STOCK UNDER NEW BATCH NUMBER								
240	QC21- Final Inspection - Work Order Release	0.00							
240									
QC	Memo	0.00							
Quality Control									

12/03/29 (12)

12/3/29

12-03-29

Picklist Print

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Work Order ID: 82060

Parent Item: D3205-3

Parent Item Name: Back Plate

Start Date: 3/22/2012

Required Date: 3/30/2012

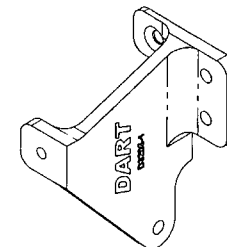
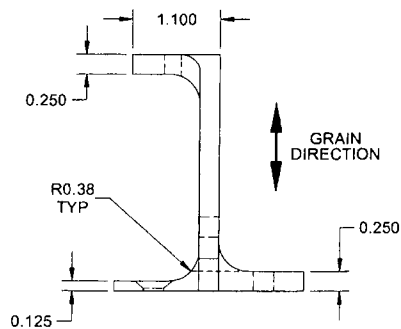
Start Qty: 12.00

Required Qty: 12.00

Comments: IPP B05.01.31 Revised Step 10KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3205-3 Back Plate		Manufactured	No				Each	0.0000		12			

2 X 69626
10 X 70285 > mf 12-03-22

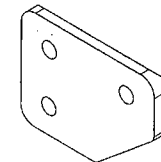
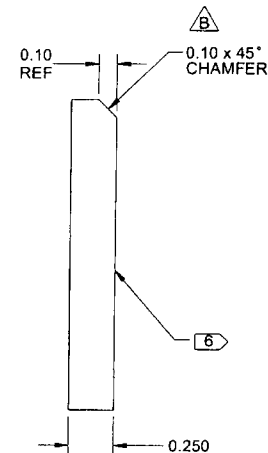
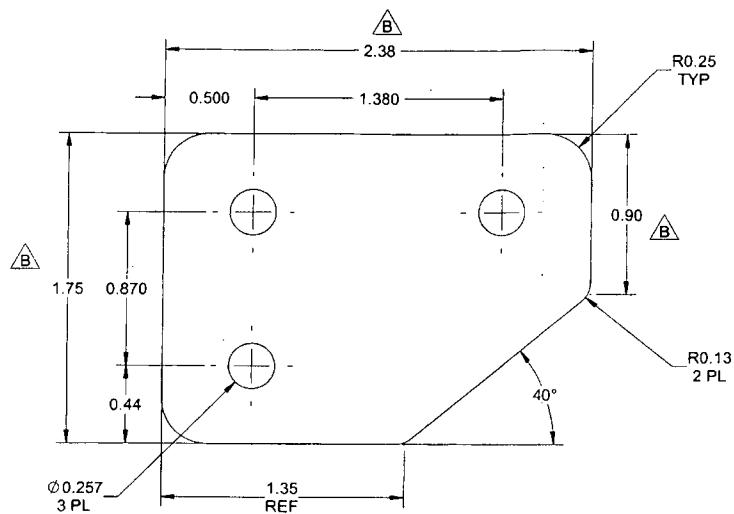


82060

RELEASED
2012-03-21
ECN 12-545 CP

NOTES:
1) MATERIAL: 7075-T73 ALUMINUM BAR
PER QQ-A-200/11 OR QQ-A-250/12
REF DART SPEC M7075T73B
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3
7) WEIGHT: 0.28 lbs

B	CONVERT DRAWING TO STANDARD FORMAT; 3.96 WAS 3.99 (ZN C2-1); 19" WAS 18" (D3-1); 42" WAS 41" (ZN C4-1); CHANGE DIMENSIONS TO 2 DEC. PL (ZN D5-1, C4-2, D5-2, C7-2); ADD CHAMFER (ZN D3-2); REMOVE ENGRAVING ON D3205-3		RF	12.02.24
A	NEW ISSUE		RF	04.01.27
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3205 TITLE BRACKET		
DRAWN	RF			
CHECKED	<i>[Signature]</i>		REV. I	OF 1
MFG. APPR.	<i>[Signature]</i>		SHEET 1	SCALE
APPROVED	<i>[Signature]</i>		NT.	
DE APPR.	<i>[Signature]</i>			
DATE	12.02.24		COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED TO THE EXTENDED CIRCULATION THAT IT IS NOT TO BE LOANED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT	



#8 2060

D3205-3 BACK PLATE

RELEASED
2012-03-21
RCN 12-545 9

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.09 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3205	SHEET 2 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	BRACKET	NTS
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